

Date: Monday, 11/6/2006 1:46:49 PM  
 User: Kign Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INLET WELDMENT (206)
<b>Job Number</b> :	29312		
<b>Estimate Number</b> :	10477		
<b>P.O. Number</b> :	NIA	<b>Part Number</b> :	D2413
<b>This Issue</b> :	11/6/2006	<b>S.O. No.</b> :	NIA
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2413 REV. A
<b>First Issue</b> :	NIA	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26905	<b>Drawing Revision</b> :	A
		<b>Material</b> :	NIA
<b>Written By</b> :		<b>Due Date</b> :	11/30/2006
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	2
<b>Comment</b> :	Est: C 09.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2292	Heater Tube 4"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Heater Tube 4"

Qty	Part Number	Description	Batch
1	D2292	4" Ring	B35339

PD 07-11-28 (4)

2.0	D2405	End Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 End Plate

Qty	Part Number	Description	Batch
1	D2405	End Plate	B26913

PD 07-11-28 (4)

3.0	D2407	3" Tubing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 3" Tubing

Qty	Part Number	Description	Batch
1	D2407	3" Tubing	B35340

PD 07-11-28 (4)

4.0	D2408	Locator Cross
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Locator Cross

Qty	Part Number	Description	Batch
1	D2408	Locator Cross	B26916

PD 07-11-28 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/6/2006 1:46:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 29312

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2409

Jet Pipe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Jet Pipe

Qty Part Number

Description

Batch

1 D2409

Jet Pipe

635355

ID 07-11-28 (4)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2413 Intake Assembly as per Dwg D2413 and QSI 004.

ID 07-11-28 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QCS → 07/12/03 (4)

QC9 → 07/12/03 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 07-12-03

(4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

M-L

4X 07/12/03

10.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5195

Red Anodize D2413 as per Dwg D2413

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

C 07/12/05

(4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Anodize & Certs.

07/12/07 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:46:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET WELDMENT (206)

Job Number: 29312

Part Number: D2413

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/12/14 SQ

(4X)

13.0

AN8188D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)  
Nut 4.000

Pick:

Qty	Part Number	Description	Batch
1	AN818-8D	Flare Nut	M103641x2 / M106074x2

FF 07-12-20

(4)

14.0

MS208198D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)  
Sleeve 4.000

Pick:

Qty	Part Number	Description	Batch
1	MS20819-8D	Sleeve	M101840

FF 07-12-20

(4)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2413. Sleeve & Flare tube as per Dwg D2413

FF 07-12-20

(4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6/12/24 (4X)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 168

AS 07/12/28

(4X)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/03

(4)

Job Completion



min 2008/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2413	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 INLET WELDMENT SCALE	

RELEASED  
96/09/10 BW

QTY	Part No.	Description
X	D2413	INTAKE WELDMENT ASSEMBLY
1	D2292	4" RING
1	D2405	END PLATE
1	D2407	3" TUBING
1	D2408	LOCATOR CROSS
1	D2409	JET PIPE
1	AN818-8D	FLARE NUT
1	MS20819-8D	SLEEVE

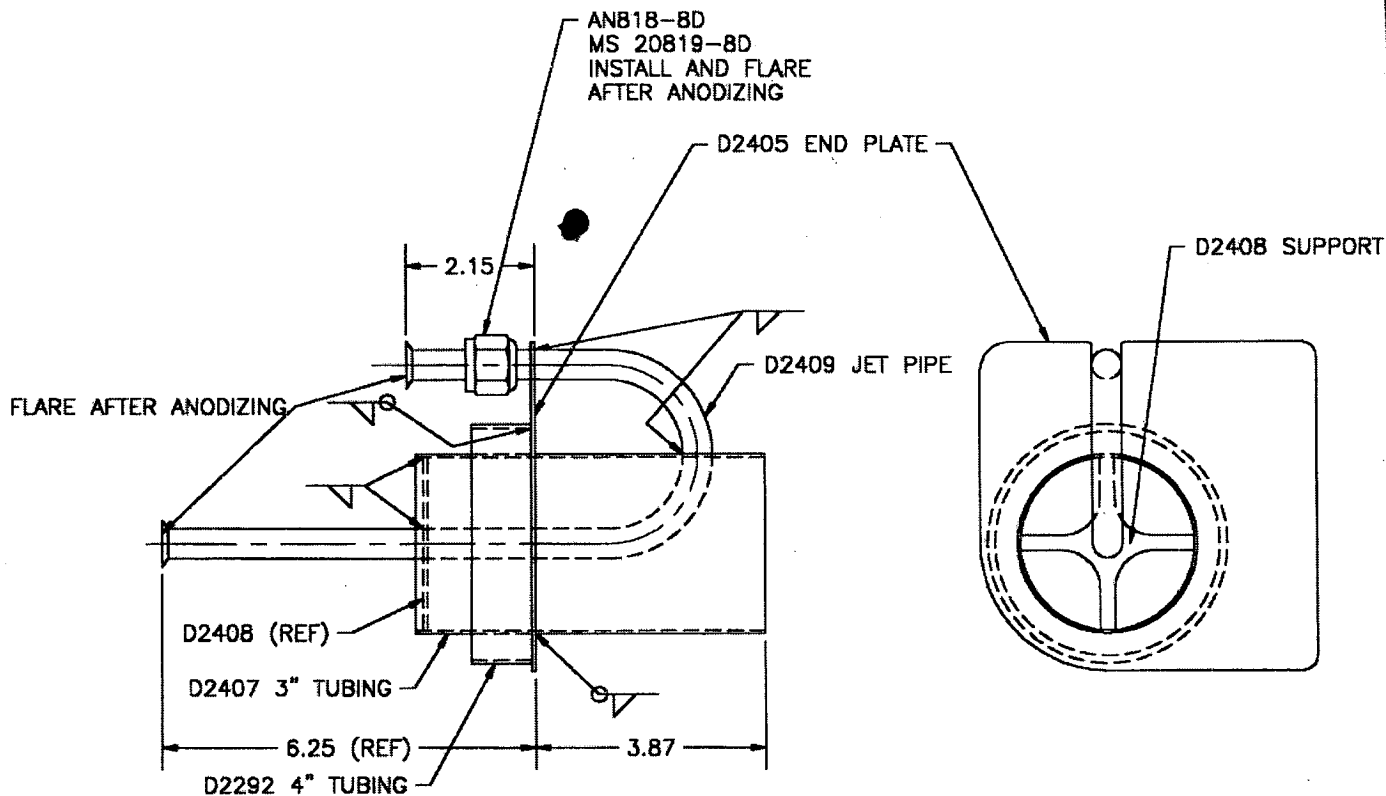
SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29312

**DART**



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BWS</i>	APPROVED <i>BWS</i>	D2413	REV. A
DATE Apr. 6, 1995		TITLE 206 INLET WELDMENT	SHEET 2 OF 2
			SCALE

RELEASED  
76107/110 (BA)



FINISH: ANODIZE

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WITHOUT NOTICE  
WORK ORDER  
NO. 29312



**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified  
approuvé NADCAP approved

60786

12-Dec-2007

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE****CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE: PO00005195**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	D2413 B29312 -	- STRIP RED ANODIZE PER MIL-8625F1 TYPE 1, CLASS 2

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

# ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

FACTURE  
INVOICE

60786 Rev.00

12-Dec-2007

## CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

## PURCHASE ORDER/

NO. DE COMMANDE: PO00005195

## CONDITIONS / TERMS:

NET 30 JOURS / NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	4	4 /	D2413 B29312 -	\$0.00	\$0.00
		7/12/14 54	MINIMUM CHARGE		\$210.00
				SUB TOTAL:	\$210.00
				TPS/GST:	\$12.60
				TVQ/PST:	\$0.00
				TOTAL AMOUNT DUE:	\$222.60

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.